

82824

Page 1

N900040100

Setup Start *NS1*

Stop ***NS2***

6

Cust Item ID:

6

Customer:

Run Start *NR1*

Tooling:

Date:

Stop *NR2*

Date:

SPC (Y/N):

Date:

Draw Nbr	Revision Nbr
D4103	A

0.00

100

PO

12/05/11

6

9

Memo

0.00

6.200" long

0.00

110

0.00

Memo

Mill as per dwg and Folio FA937

DEBURR

0.00

120

0.00

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Tuesday, April 10, 2012 11:49:27 AM

82824

Page 3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name:	Step / Handle
------------	---------------

Stop *NS2*

Start Date: 4/10/2012 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 4/27/2012 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

160

Identify as per dwg & Stock Location: 5-2-10 0.00

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

6x _____ SP
12-5-22

12/15/22 JF

MF
12-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 10, 2012 11:49:26 AM

Page 1

Work Order ID: 82824

Parent Item: D4103-1

Parent Item Name: Step / Handle

Start Date: 4/10/2012

Required Date: 4/27/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV: A NEW ISSUE 10-07-01 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.500 6061-T6 Bar 2.00 x 3.50		Purchased	No			100	f	15.0061	0.52	3.2842105			

Location	Loc Qty	Loc Code
MAT009	15.0061	
112764	0.7284	
→ 118182	11.4527	12.0
118641	2.825	

PD 12/05/11

3.3

Dart Aerospace Ltd

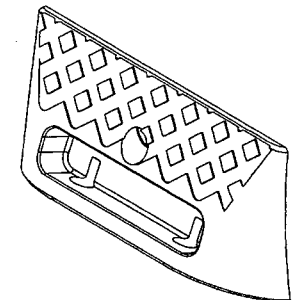
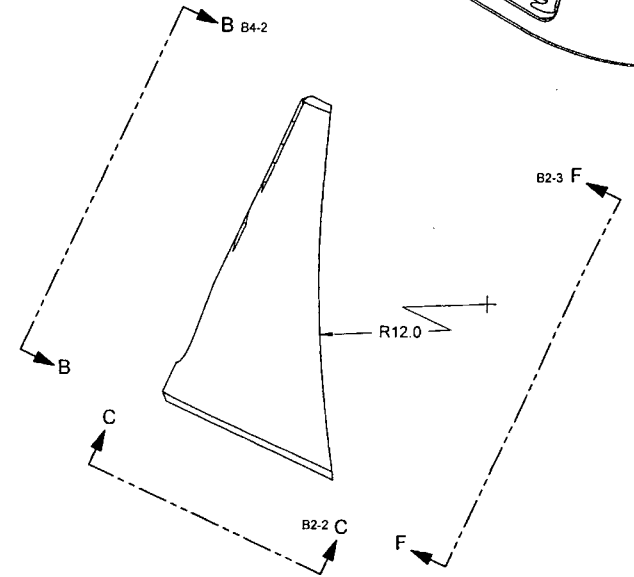
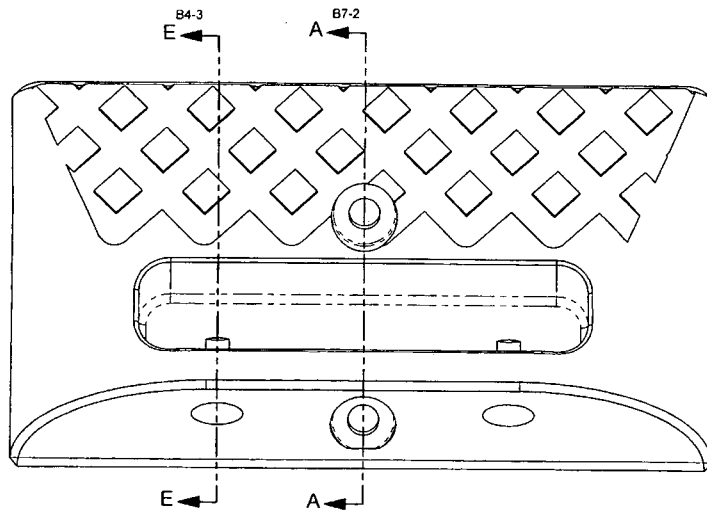
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82824



D4103-1 STEP/HANDLE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4103-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.81 lbs
- 8) MACHINE 0.28 x 0.31 GRIP 0.030 DEEP AT 45° PATTERN 0.25 APART

RELEASED
2010-08-23
JWP

A NEW ISSUE		RF		10.05.17
REV.	DESCRIPTION	BY	DATE	
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	RF	DRAWING NO.		REV. A
MFG. APPR.	RF	D4103		SHEET 1 OF 3
APPROVED	RF	TITLE		SCALE
DE APPR.	RF	STEP/HANDLE		NTS
DATE 10.05.17		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

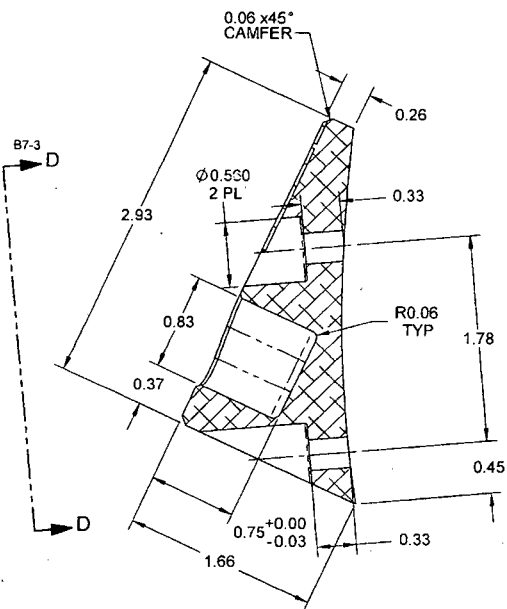
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

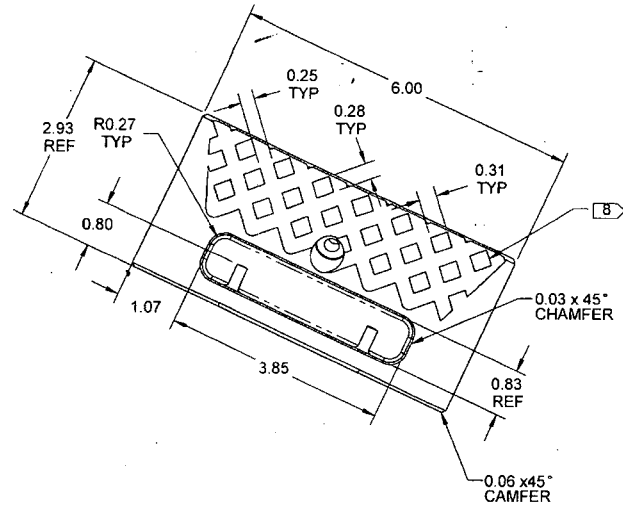
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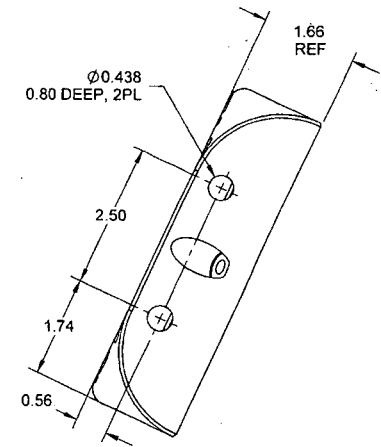
8 7 6 5 4 3 2 1



SECTION A-A D6-1



VIEW B-B D3-1
SCALE 0.5X



VIEW C-C B2-1
SCALE 0.5X

#82824

RELEASED
2010-08-23

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	#	DRAWING NO.	REV. A
MFG. APPR.	#	D4103	SHEET 2 OF 3
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DE APPR.	#	STEP/HANDLE	NTS
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8 7 6 5 4 3 2 1

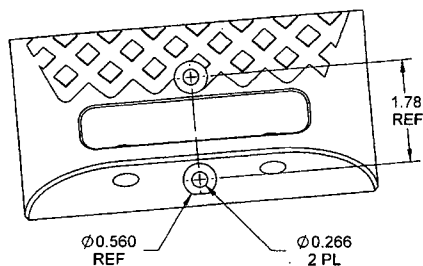
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

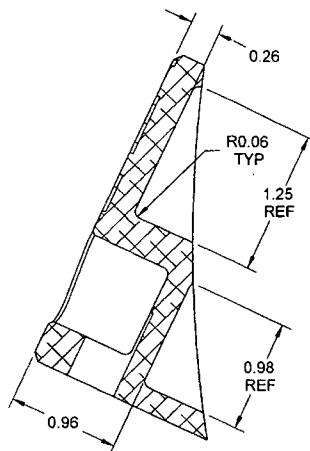
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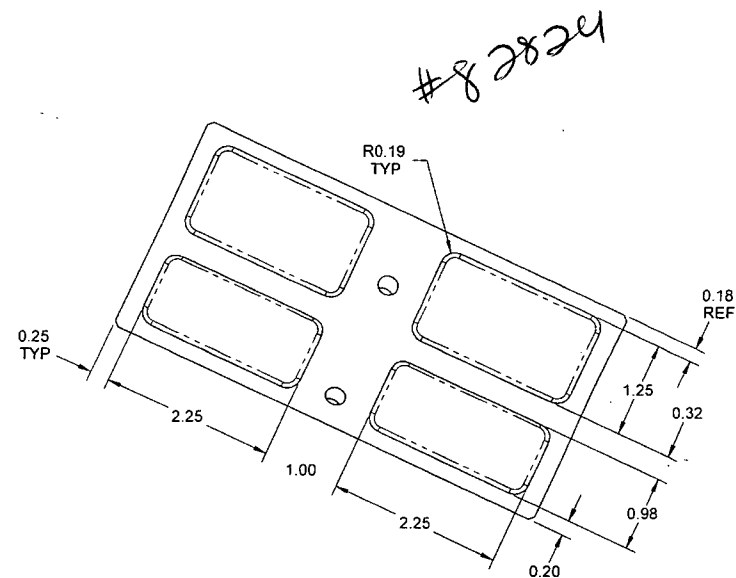
NOTE: Date & initial all entries



VIEW D-D C8-2
SCALE 0.5X



VIEW E-E D7-1



VIEW F-F C1-1

RELEASED
2010-08-23
AND

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	#	DRAWING NO. D4103	REV. A
MFG. APPR.	#		SHEET 3 OF 3
APPROVED	#	TITLE	SCALE
DE APPR.	#	STEP/HANDLE	NTS
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DART AEROSPACE LTD		Work Order: 52824
Description: Step/Handle		Part Number: D4103-1
Inspection Dwg: D4103	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.93	+/-0.030	2.93	✓		vern	RT - 4
0.37	+/-0.030	.369	✓		"	
0.83	+/-0.030	.831	✓		"	
Ø0.560	+/-0.010	.557	✓		"	
0.06 X 45°	+/-0.030 X +/-0.5°	.050	✓		"	
0.26	+/-0.030	.237	✓		"	
0.33	+/-0.030	.310	✓		mic	118 120
R0.06	+/-0.030	.06	✓		rad gauge	
1.78	+/-0.030	1.785	✓		vern	RT - 4
0.45	+/-0.030	.433	✓		"	
0.33	+/-0.030	.310	✓		"	
0.75	+0.000/-0.030	.749	✓		depth gauge	RT - 6
1.66	+/-0.030	1.640	✓		vern	RT - 4
0.80	+/-0.030	.804	✓		"	
1.07	+/-0.030	1.062	✓		height gauge	31006
3.85	+/-0.030	3.849	✓		vern	RT - 4
0.03 X 45°	+/-0.030 X +/-0.5°	.030	✓		"	
0.31	+/-0.030	.305	✓		"	
0.28	+/-0.030	.280	✓		"	
0.030 Deep	+/-0.030	.030	✓		depth gauge	RT - 6
6.00	+/-0.030	5.970	✓		vern	RT - 4
R0.27	+/-0.030	.265	✓		rad gauge	
0.56	+/-0.030	.559	✓		vern	RT - 4
1.74	+/-0.030	1.740	✓		height gauge	31006
2.50	+/-0.030	2.498	✓		vern	RT - 4
Ø0.438	+0.006/-0.001	.444	✓		"	
Ø0.266	+0.006/-0.001	.266	✓		"	
0.96	+/-0.030	.945	✓		height gauge	31006
0.26	+/-0.030	.247	✓		"	
0.25	+/-0.030	.234	✓		vern	RT - 4
2.25	+/-0.030	2.248	✓		"	
1.00	+/-0.030	.999	✓		"	
0.20	+/-0.030	.176	✓		"	
0.98	+/-0.030	.982	✓		"	
0.32	+/-0.030	.316	✓		"	
1.25	+/-0.030	1.251	✓		"	
R0.19	+/-0.030	.190	✓		"	

Measured by: RT	Audited by: ZP	Preliminary Approval:
Date: 12-05-13	Date: 12-05-13	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	